

# Work Order ID 82627

April-04-12 10:48:36 AM

**\*82627\***

Page 1

Item ID: D4277-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib  
 Start Date: 04/04/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 30/04/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4277	D								

100 0.00  
**\*100\***  
 Large Fab Memo 0.00  
 Large Fab 1- Cut tube as per dwg D4277  
 2- Remove marking and deburr  
2 SMD B 05-22

110 QC6- Inspect dimensions to drawing 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control  
27 Ø Pl 12 05 22

120 Identify as per dwg & Stock Location: WA 0.00  
**\*120\***  
 Packaging Memo 0.00  
 Packaging \*\*\*STOCK IN BASKET CELL\*\*\*  
27 Ø Pl 12 05 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*82627\***

Page 2

**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

**Start Date:** 04/04/2012    **Start Qty:** 2.00    **\*2\***

**Required Date:** 30/04/2012      **Req'd Qty:** 2.00      **\*2\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

0.00

0.00

## Memo

## Quality Control

12/15/22 MF 12-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-04-12 10:48:40 AM

Page 1

Work Order ID: 82627

**\*82627\***

Parent Item: D4277-3

**\*D4277-3\***

Parent Item Name: Rib

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

61.7688

0.52

1.094737

**\*M304TS0 500W 049\***

**\*\***

*SAD 12-05-22*

Square Tubing

Location

Loc Qty

Loc Code

MAT034

61.76881534

116610

0.8383

117721

0.3234

117999

2.43919739

118460

58.167918

*M121328*

*1.0948*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D4277-1 RIB

D4277-3 RIB

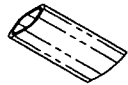
D4277-5 RIB

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 82623 MLC  
12/04/04

C

C



D4277-7 RIB

D4277-9 RIB

B

B

D4277-11 RIB

RELEASED  
2011-02-24  
MD

A

A

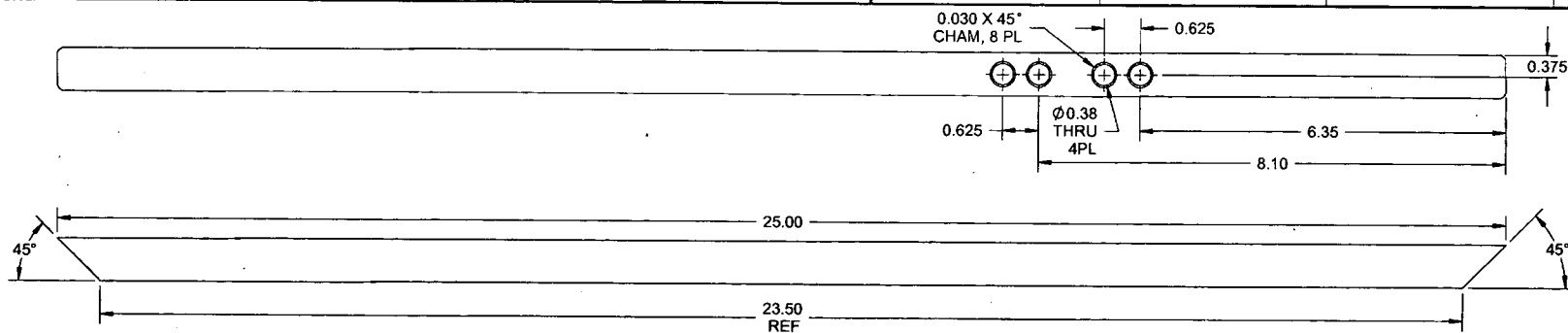
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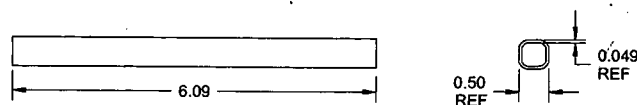
8 7 6 5 4 3 2 1

D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/15/17 (OBSOLETE); -3: 8.09 WAS 20.25 (C5-2); -8: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 28.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
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MFG. APPR.	h	D4277	SHEET 1 OF 3
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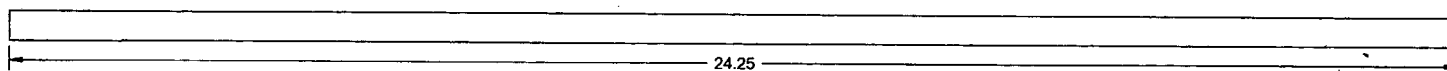
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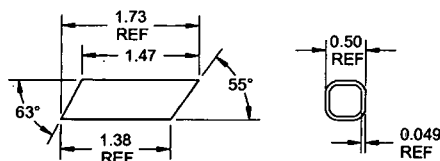
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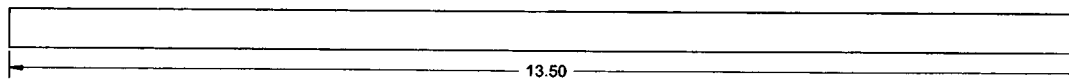
**D4277-3 RIB**



**D4277-5 RIB**



**D4277-7 RIB**







**D4277-9 RIB**

RELEASED  
2011-02-27

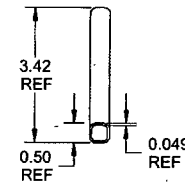
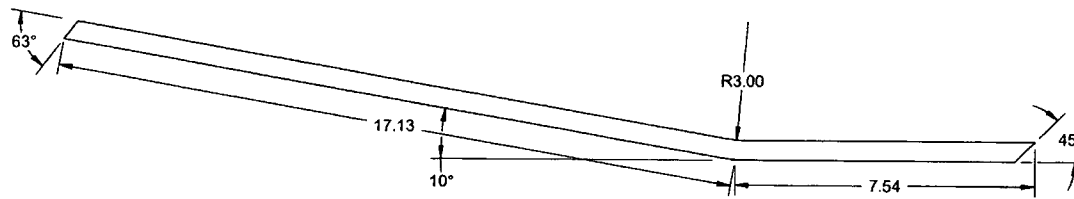
**NOTES:**

- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049  
-3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

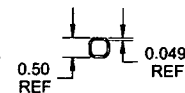
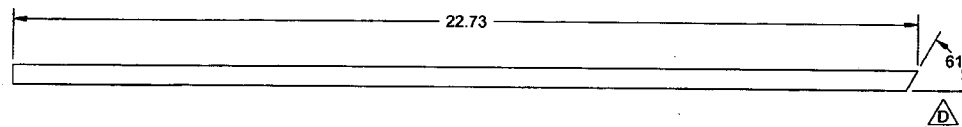
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82627



**D4277-11 RIB**



**D4277-19 RIB**

RELEASED  
2011-02-24

**NOTES:**

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

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